

Work Order ID 136617

Thursday, September 03, 2015 8:14:01 AM

136617

Page 1

Item ID: D4798-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Wearplate Assembly
Start Date: 9/1/2015 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 9/1/2015 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: MLJ Date: SEP 04 2015 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4798	B								

100

0.00

100

Waterjet

FLOW CNC Waterjet

Memo

1-Cut D4798-1 as per Dwg

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

SCRAP

0.00

(4)

02/15/10/06

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.00

(4)

02/15/10/06

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Past Expiry Date ☐	Manufacturing Process ☐																								
Misidentified ☐	Past Due ☐																								
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							DAS 38 9-89
120									
QC	Memo	0.00							
Quality Control									
130		0.00							
130									
Large Fab	Memo	0.00							
Large Fab	***USE DT9891 WELDING FIXTURE***								
	1- Weld cups as per dwg A/R S.S. ROD BATCH: _____								
	2- Apply hardfacing on wearplate as indicated on dwg A/R HARDCOAT 2059B BATCH: _____								
140	QC5- Inspect part completeness to step on W/O	0.00							
140									
QC	Memo	0.00							
Quality Control									

P.T.O.

OCT 02 2015

DQA:

Date: 16/02/02



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed

Date: 16/02/02

Work Order update only ☐

Work Order: <u>136612</u> Part No. <u>D4798-041</u> NCR No. _____		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☒</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☒	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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part is now under prelim. with some dimension change R.C. design				scrap & destroy no replace																																																																			
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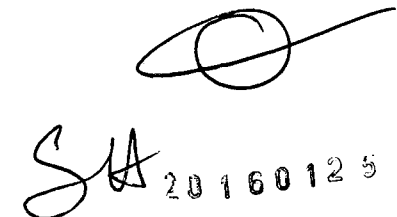
136617

Page 3

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Revision ID: Stop ***NS2***
Item Name: Wearplate Assembly
Start Date: 9/1/2015 Start Qty: 4.00 ***4*** Cust Item ID:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
150									
QC	Memo	0.00							
Quality Control									
160	Identify as per dwg & Stock Location: _____	0.00							
160									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									



20160125

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
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Root Cause		FAULT CATEGORY			
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OTHER : ☐					

Picklist Print

Thursday, September 03, 2015 8:14:05 AM

Page 1

Work Order ID: 136617

136617

Parent Item: D4798-041

D4798-041

Parent Item Name: Wearplate Assembly

Start Date: 9/1/2015

Required Date: 9/1/2015

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A NEW ISSUE 13-03-26 JLM VERIFIED BY:DD IPP
REV:B 13.05.28 AS PER DWG REV.B DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4379-1		Manufactured	No				Each	26.0000		40			

D4379-1

Wearplate Cup

Location Loc Qty Loc Code

WA002 26

133469 26

M304S16GA Purchased No

sf 268.9900

4.842105

M304S16GA

304/316 Sheet .063

Location Loc Qty Loc Code

MAT019 268.99

m131384 35.2

m131503 7.79

m132797 64

m132835 162

4.8

09/15/10/06

DQA: _____ Date: _____



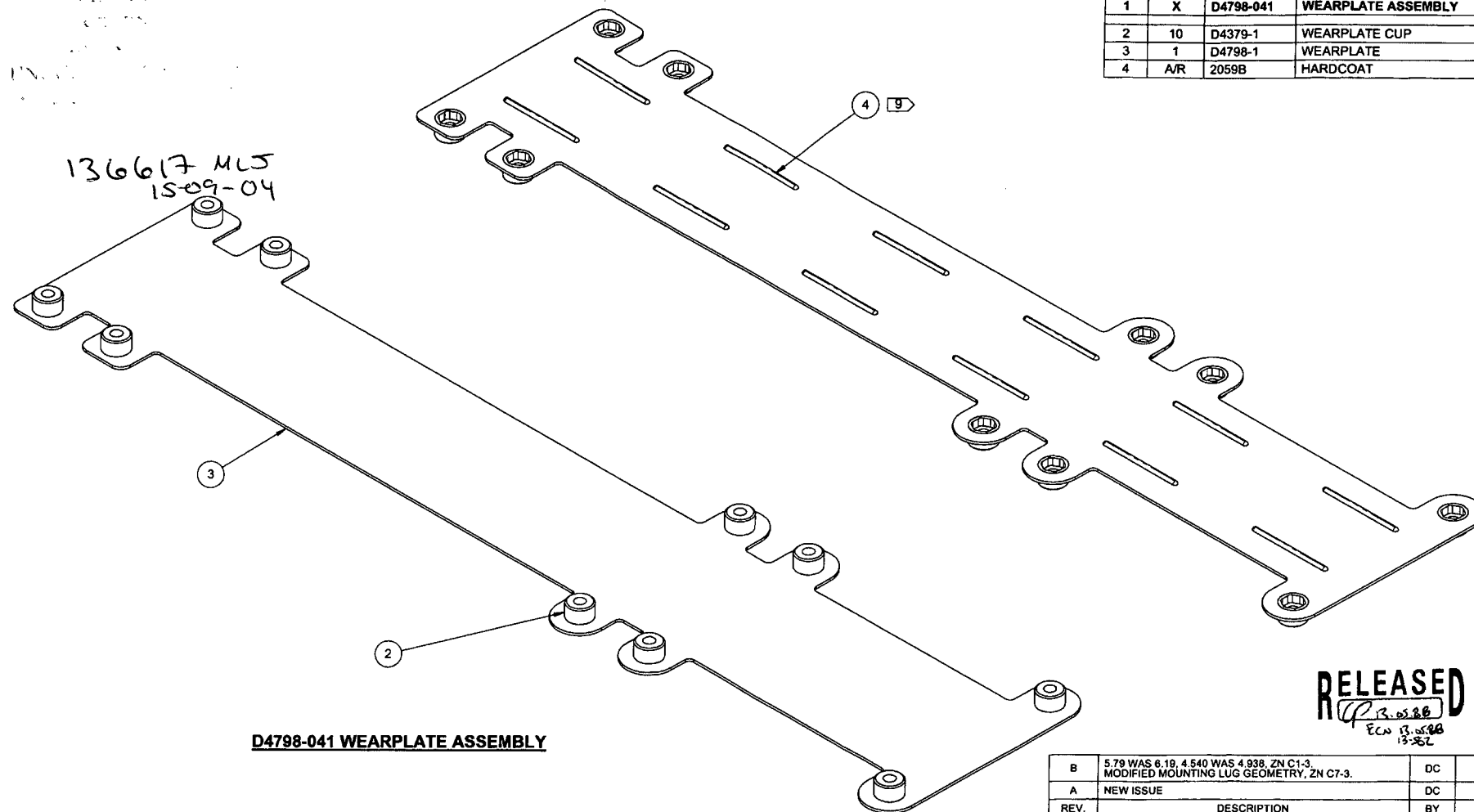
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OTHER : ☐																					

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D4798-041	WEARPLATE ASSEMBLY
2	10	D4379-1	WEARPLATE CUP
3	1	D4798-1	WEARPLATE
4	A/R	2059B	HARDCOAT



RELEASED
ECN 13-0528
13-062

D4798-041 WEARPLATE ASSEMBLY

NOTES:

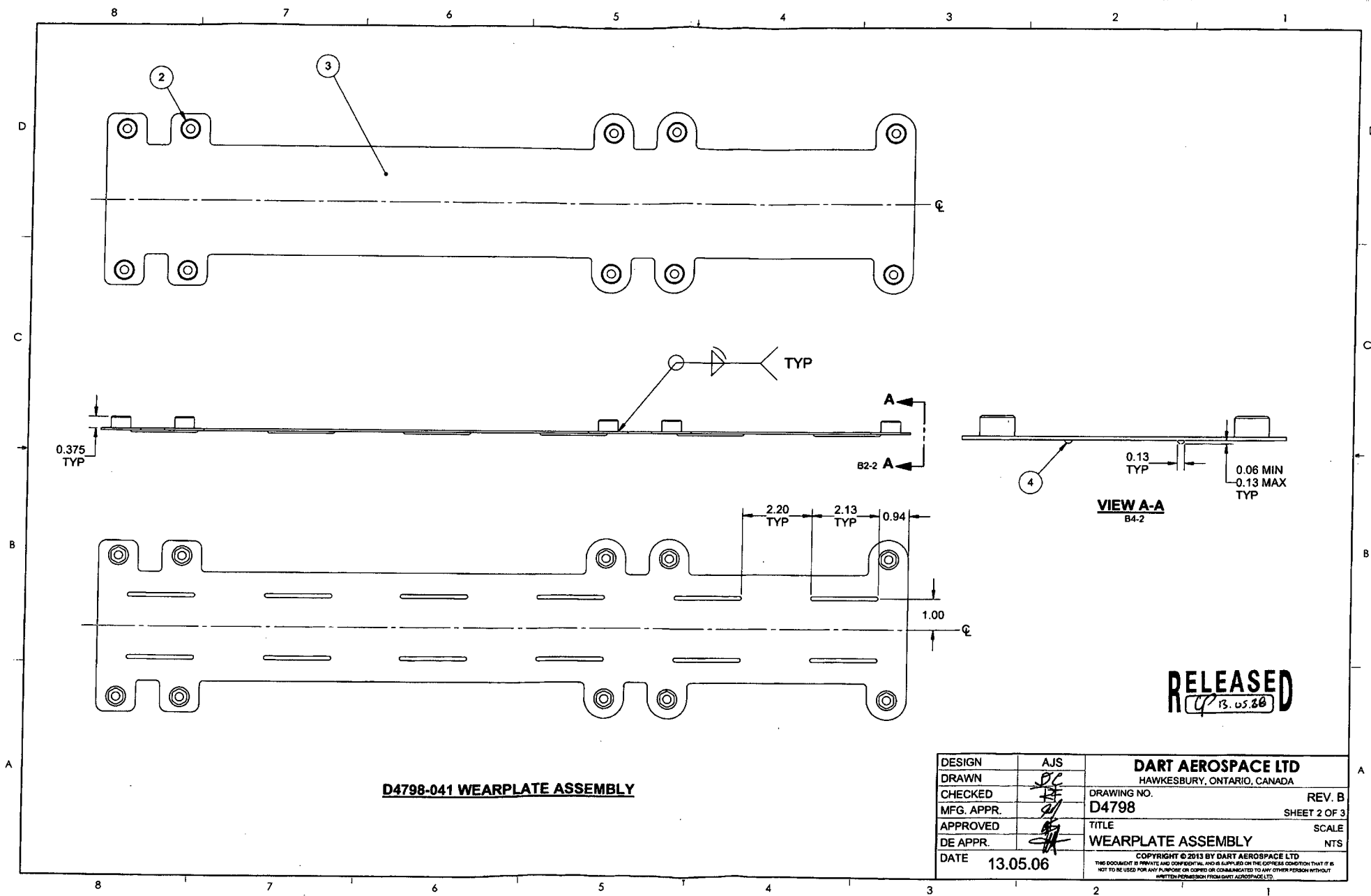
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1
- 7) WEIGHT: 2.05 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 12 PL

B	5.79 WAS 6.19, 4.540 WAS 4.938, ZN C1-3, MODIFIED MOUNTING LUG GEOMETRY, ZN C7-3.	DC	13.05.06
A	NEW ISSUE	DC	13.03.20
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	DC		
CHECKED	DC		
MFG. APPR.	DC		
APPROVED	DC		
DE APPR.	DC		
DATE	13.05.06		

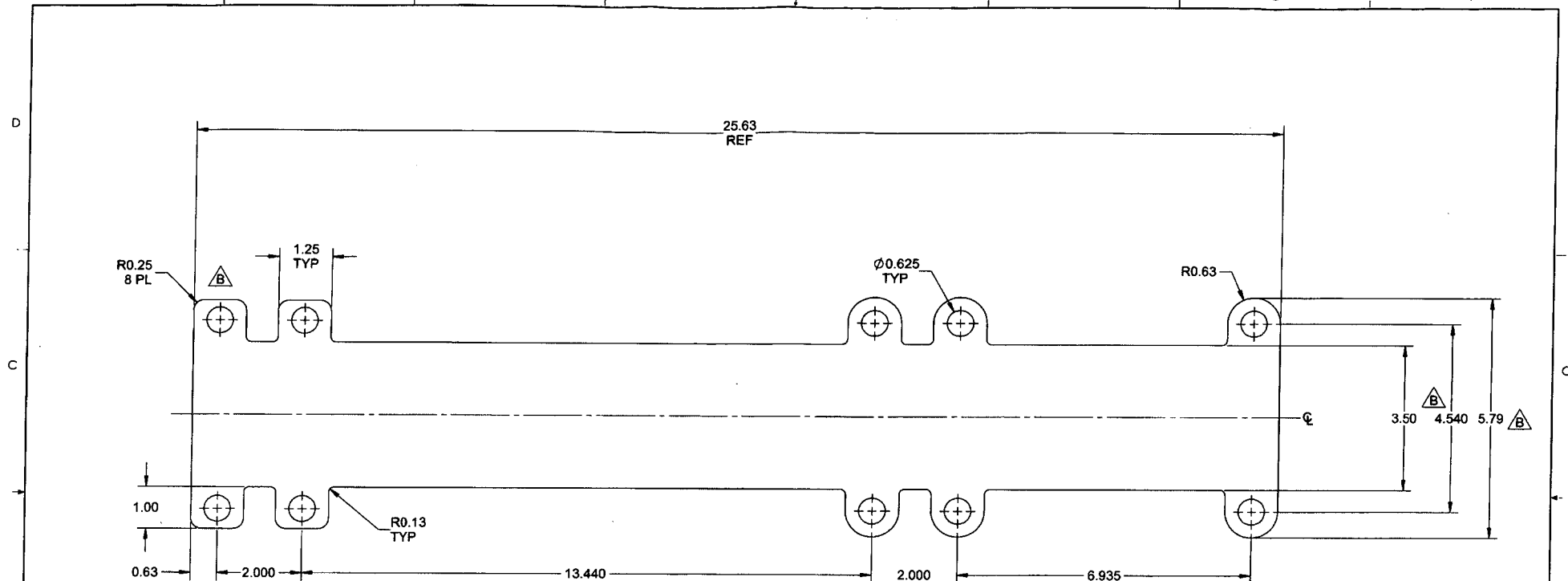
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4798** REV. B
TITLE **WEARPLATE ASSEMBLY** SCALE NTS
SHEET 1 OF 3

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D4798-1 WEARPLATE

RELEASED
13.05.06

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 16 GAUGE (0.063 THICK)
PER AMS 5513 (304) OR 5524 (316) OR ASTM A240 OR ASME SA240
REF DART SPEC. M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.82 lbs

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	PC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PC	DRAWING NO.	REV. B
MFG. APPR.	PC	D4798	SHEET 3 OF 3
APPROVED	PC	TITLE	SCALE
DE APPR.	PC	WEARPLATE ASSEMBLY	NTS
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